

Work Order ID 144586

April 21, 2016 12:47:36 PM

144586

Page 1

Item ID: D412-760-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Cabin Floor Protector

Stop ***NS2***

Start Date: 4/25/2016 Start Qty: 100

Required Date: 4/25/2016 Req'd Qty: 100

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: SM D412-760-011 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
IIN-D412-760	G								

100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork		Photocopy bluefile & type labels per PPP D412-760-011 CHG002							

APR 26 2016

110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									

APR 25 2016

120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.03							
Quality Control									

APR 26 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

Work Order ID 144586***144586***

Page 2

April 21, 2016 12:47:36 PM

Item ID: D412-760-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cabin Floor Protector

Start Date: 4/25/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/29/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00

130

Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D412-760-011

Location: FG049

F6040

4 DAS DAS
28 27
9-89 9-89
APR 26 2016

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.10

Quality Control

MS APR 26 2016

MF
16-4-26

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Picklist Print

April 21, 2016 12:47:41 PM

Page 1

Work Order ID: 144586

144586

Parent Item: D412-760-011

D412-760-011

Parent Item Name: Cabin Floor Protector

Start Date: 4/25/2016

Required Date: 4/29/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev A 07.07.05 new issue EC
IPP Rev:B 08-08-20 revB as per dwg DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3574-1 *D3574-1* Cabin Floor Protector DAS 27 9-89		Manufactured	No			110	Each	0.0000	1	4			DAS 28 9-89
D3574-2 *D3574-2* Cabin Floor Protector DAS 27 9-89		Manufactured	No			110	Each	0.0000	1	4			DAS 28 9-89
D3575-1 *D3575-1* Cargo Floor Protector DAS 27 9-89		Manufactured	No			110	Each	0.0000	1	4			DAS 28 9-89
D3575-2 *D3575-2* Cargo Floor Protector DAS 27 9-89		Manufactured	No			110	Each	0.0000	1	4			DAS 28 9-89
D3580-1 *D3580-1* Joggle Bracket DAS 27 9-89		Manufactured	No			110	Each	13.0000	6	24			DAS 28 9-89

Location

Loc Qty

Loc Code

ST043

13

141568

13

13

Picklist Print

April 21, 2016 12:47:41 PM

Page 2

Work Order ID: 144586

144586

Parent Item: D412-760-011

D412-760-011

Parent Item Name: Cabin Floor Protector

Start Date: 4/25/2016

Required Date: 4/29/2016

Start Qty: 1.00

Required Qty: 1.00

D3628-1 Manufactured No

110 Each

383.0000

14

14 56

D3628-1

Washer, Cupped

**

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

10

83587

10

ST046

123

140056

123

ST051A

250

142000

250

D3628-3 Manufactured No

110 Each

105.0000

6

6 16

D3628-3

Cupped Washer

**

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST046

105

96308

105

MS24694-S100 Purchased No

110 Each

122.0000

6

6 10

MS24694-S100

Flat Head Screw

**

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST283

122

m132823

2

m134376

20

m134574

100

MS24694-S54 Purchased No

110 Each

93.0000

14

14 56

MS24694-S54

SCREW

**

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST284

93

m134376

93

56

APR 25 2016

April 21, 2016 12:47:42 PM

Shop Packet Print

Page 2

Picklist Print

April 21, 2016 12:47:42 PM

Page 3

Work Order ID: 144586

144586

Parent Item: D412-760-011

D412-760-011

Parent Item Name: Cabin Floor Protector

Start Date: 4/25/2016

Required Date: 4/29/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0363J

Purchased

No

110

Each

1,911.000

28

28 112

NAS1149D0363.J

Washer

**

DAS
27
9-89
DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

GA	583
m134055	583
ST263	1328
m134370	328
m134606	1000

112

NAS1149D0463J

Purchased

No

110

Each

3,137.000

12

12 48

NAS1149D0463.J

WASHER

**

DAS
27
9-89
DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

GA	383
M129390	41
M132035	21
M134508	321
ST260a	1725
M134508	600
M134573	1125
ST263	41
M134039	41
ST269	988
M132317	100
M132677	888

48

APR 25 2016

5.0 PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -017	Qty -019	Part Number	Description
X					D412-760-011	CABIN FLOOR PROTECTOR KIT
	X				D412-760-013	CABIN FLOOR PROTECTOR KIT
		X			D412-760-015	CABIN FLOOR PROTECTOR KIT
			X		D412-760-017	CABIN FLOOR PROTECTOR KIT
				X	D412-760-019	CABIN FLOOR PROTECTOR KIT
1					D3574-1	CABIN FLOOR PROTECTOR
1					D3574-2	CABIN FLOOR PROTECTOR
	1				D3574-3	CABIN FLOOR PROTECTOR
	1				D3574-4	CABIN FLOOR PROTECTOR
		1			D3574-5	CABIN FLOOR PROTECTOR
		1			D3574-6	CABIN FLOOR PROTECTOR
1					D3575-1	CABIN FLOOR PROTECTOR
1					D3575-2	CABIN FLOOR PROTECTOR
	1				D3575-3	CABIN FLOOR PROTECTOR
	1				D3575-4	CABIN FLOOR PROTECTOR
		1			D3575-5	CABIN FLOOR PROTECTOR
		1			D3575-6	CABIN FLOOR PROTECTOR
6	4	6	6	6	D3580-1	JOGGLE BRACKET
			1		D3788-1	CABIN FLOOR PROTECTOR
			1		D3788-2	CABIN FLOOR PROTECTOR
			1		D3788-3	CABIN FLOOR PROTECTOR
			1		D3788-4	CABIN FLOOR PROTECTOR
14	40	14	14	10	D3628-1	CUPPED WASHER
6	8	6	6		D3628-3	CUPPED WASHER
				1	D4122-1	FLOOR PROTECTOR, FORWARD
				1	D4122-3	FLOOR PROTECTOR, AFT
28		28	28		NAS1149D0363J	WASHER (AN960JD10)
12		12	12		NAS1149D0463J	WASHER (AN960JD416)
14		14	14		MS24694S54	SCREW
1 6		6	6		MS24694S100	SCREW